

Date: Thursday, 1/24/2008 10:00:04 AM
 User: David Duval

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D412-664-203	
Job Number	: 36957		Part Number	: D412664203	
Estimate Number	: 10804		Drawing Number	: RTN665	
P.O. Number	:		Project Number	:	
This Issue	: 1/24/2008	S.O. No. :	Drawing Revision	:	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type : LANDING GEAR	Due Date	: 1/31/2008	Qty: 1 Um: Each
Previous Run	: 00015				
Written By	: <u>JW</u>				
Checked & Approved By	:				
Comment	:				

Additional Product

Job Number:	
-------------	---

Seq. #:	Machine Or Operation:	Description :
1.0	QC5	INSPECT WORK TO CURRENT STEP 

Comment: INSPECT WORK TO CURRENT STEP

2.0	D412664203 A	Crosstube Aft High 
-----	--------------	---

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube Aft High
 Qty 1. From RTN 665. D412-664-203 original B29386 (custom w/o)

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1 
-----	----------------	--

Comment: LANDING GEAR RESOURCE 1

Remove and discard all hardware.

DO NOT disacard the D2869-1 support. Carefully remove the D2869-1 center support, using a UHMW plastic block, to ensure the part does not get damaged.

***** DO NOT USE A CHIZZZZLE *****

ATT 08-02-01

- strip tube.
- Alodine exterior is necessary, as per QSI 005

AWM 08-02-05

4.0	QC5	INSPECT WORK TO CURRENT STEP 
-----	-----	---

Comment: INSPECT WORK TO CURRENT STEP

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Drawing Name: D412-664-203

Job Number: 36957

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

M 08 02 26 (1)
BT 08-02-06

2-Paint outside crosstube with White Imron as per QSI 005 4.2

6.0 QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

08/02/21 C

7.0 D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0492 sf(s)/Unit Total : 0.0492 sf(s)

Rubber Cushion (per sq ft)

.630" x5.70" x2pcs

Batch: 35126

8.0 D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip 36388

BT 08-02-12

9.0 D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1 Chafing Shield 36065

BT 08-02-12

10.0 MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp 106864

BT 08-02-12

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Drawing Name: D412-664-203

Job Number: 36957

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 MS2192030 clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
clamp(per MIL-DTL-8783C)
batch: 106870

12.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203

~~Time: 11:30 am~~

BT 08-02-26

1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond Batch: 105379

Expiry Date: 05/2008

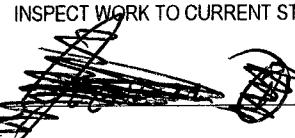
ml 08/02/21

2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

13.0 QC5 INSPECT WORK TO CURRENT STEP.



Comment: INSPECT WORK TO CURRENT STEP



08/02/03 (X)

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

15.0 AN640A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M106516

560

(1)

16.0 AN641A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M104427

8/3/3 So

(1)

~~NON - Conformance~~

~~Specification~~

~~2. Off center
of center in the magnet
bond~~

~~Nonconformance~~

Date: Thursday, 1/24/2008 10:00:05 AM
User: David Duval

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-664-203

Job Number: 36957

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M106883

SP

(1)

18.0 MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M105071

8/3/3 50

(1)

19.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

ED 08/03/08 (1)

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

Time & date of packaging: 08/03/08 2:15 PM

Location:

PPP Rev: 06

1. d3/3 0

21.0 QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

AP 08/03/08

Job Completion



U 08/03/26

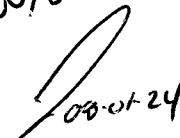
DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>QP</i>	APPROVED <i>[initials]</i>	DRAWING NO. D412-664-243 REV. D SHEET 1 OF 3
DATE 07.03.09		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) SCALE NTS

RELEASED

07.04.24 - #

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D3595-063-570	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

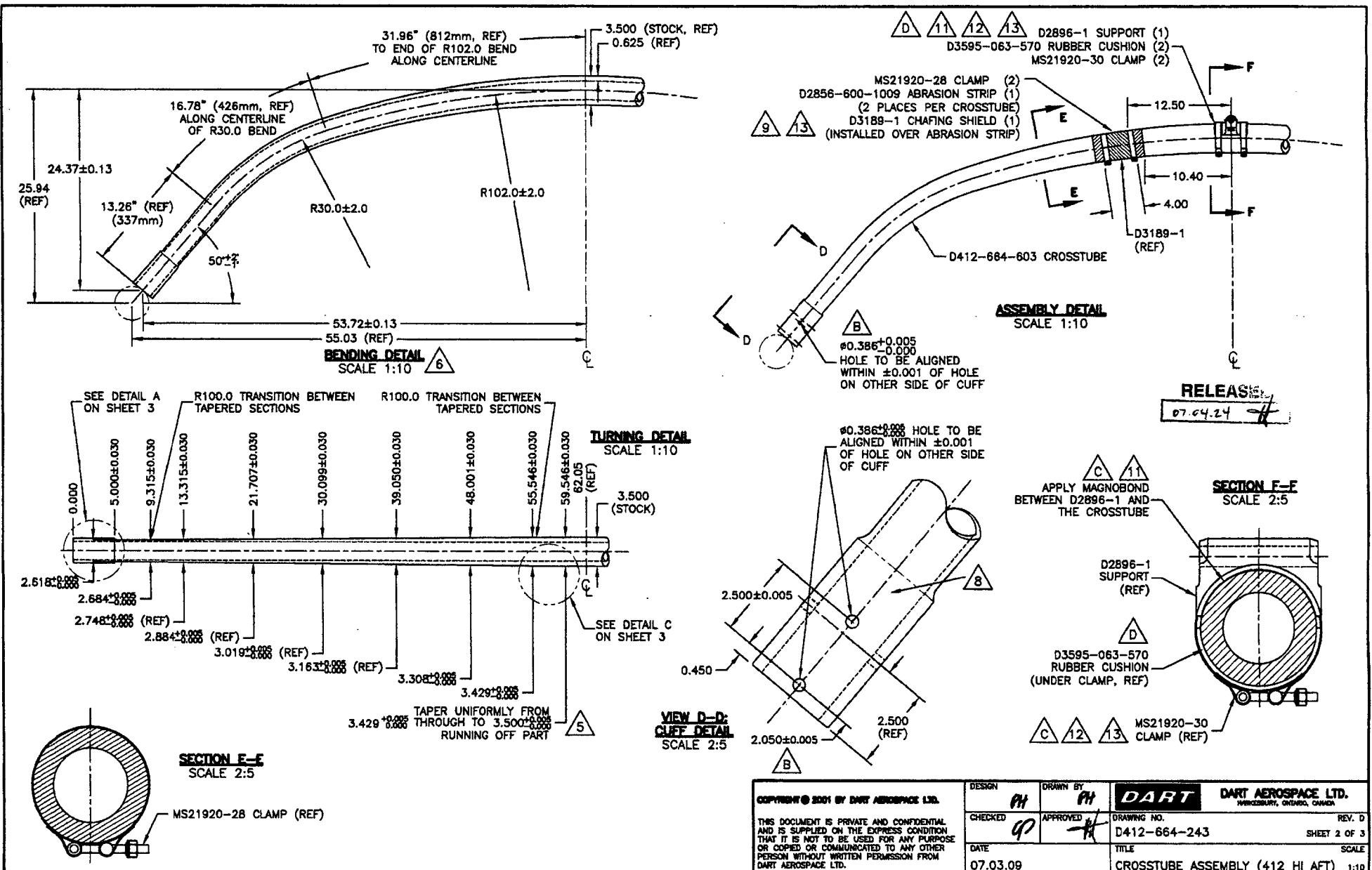
W/D 36957

 08-04-24

GENERAL NOTES:

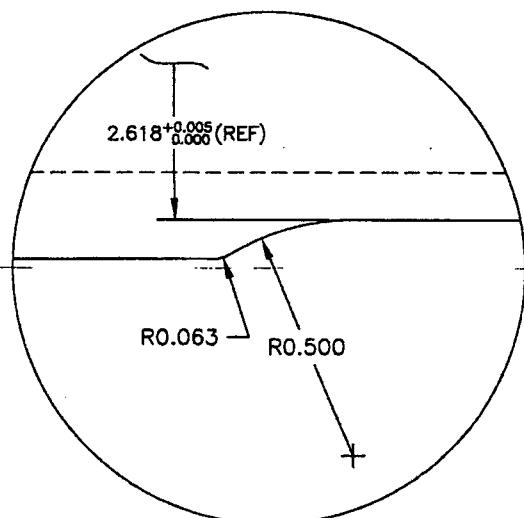
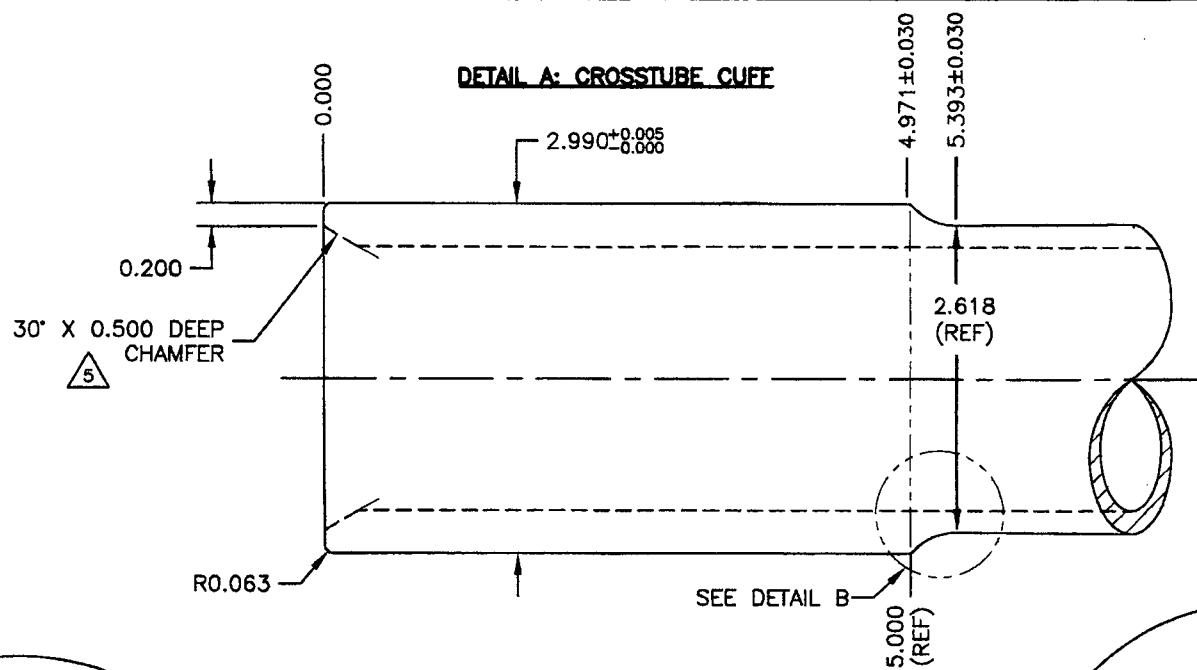
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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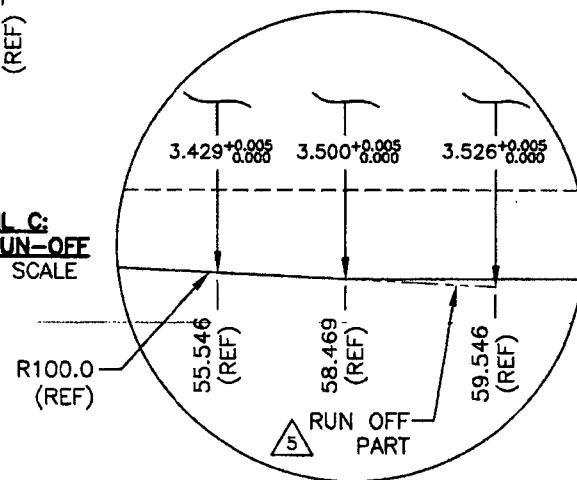
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RELEASED
07-04-244
PER BCN 889



**DETAIL C:
TAPER RUN-OFF**
NOT TO SCALE



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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HARBOUR, ONTARIO, CANADA
PH	PH	APPROVED	REV. D DRAWING NO. D412-664-243 SHEET 3 OF 3
CHECKED	APPROVED	DATE	SCALE 07.03.09 CROSSTUBE ASSEMBLY (412 HI AFT) 1:1

ME-10-99
VS 01M

R665.

3095
2471> 412-664-205
329386**Sian Willems**

From: Sian Willems [swillems@dart Aero.com]
Sent: November 12, 2007 1:50 PM
To: 'Richard.Fournier@dhl.com'
Cc: 'doris.lee@kuehne-nagel.com'; 'S Bedford'; 'Brigitte Golden'; 'Dale Trepanier'; 'Bill Beckett'; 'Bristoweng Mauritania'; 'Kelvin Fletcher'; 'Peggy McDonald'
Subject: FW: returning crosstube
Attachments: R665 Bristow Mauritania D412-664-203 Crosstube.xls

Hi Richard,

We spoke last week about the best way to return a crate from Mauritania. At that time you suggested that you could have the crate returned to Canada by DHL Express on your DHL Global Forwarding account, have it cleared by our customs broker then you would take care of the delivery to our location in Hawkesbury. I would like at this time to set this up with you.

Please find below the relevant details:

Pick up: Bristow Helicopters Mauritania
 c/o Mauritania Helicopter Services
 Aeroporte de Mauritania
 Nouakchott, Mauritania
 Contact: David (Bill) Coady
 Tel: +22 26 761 359

Customs Broker: Kuehne & Nagel

Delivery: Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Contact: Sian Willems
 Tel: 1-613-632-5200

Reference number: R665

Our DHL Global Forwarding account number is 970810058.

Crate dims are 113" x 34" x 7", approximate weight is 60 lbs.

I have attached for your reference the commercial invoice to be used for the shipment.

The freight is ready to be picked up at the customer's location.

Please call me with any questions or if I have neglected to include any information.

Sian Willems

Marketing
 T - 1.613.632.5200
 F - 1.613.632.1185
 C - 1.613.676.0577
swillems@dart Aero.com
DART Aerospace Ltd.

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.5.503 / Virus Database: 269.15.30/1125 - Release Date: 11/11/2007 9:50 PM

No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.5.503 / Virus Database: 269.15.30/1125 - Release Date: 11/11/2007 9:50 PM

**Commercial Invoice: R665**

Ship From: Bristow Helicopters Mauritania
c/o Mauritania Helicopter Services
Aeroport de Mauritania
Nouakchott, Mauritania
attn: David (Bill) Coady
Tel: +22 26 761 359

Ship To: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada
Tel # 1.613.632.5200
GST # RT101272607

Date: 12-Nov-07 **P.O. #:** R665

Ship Via: DHL **FOB:** Exworks Origin

Item	Part Number / Product Description	Tariff Class.	Quantity	Unit Price	Total
1	D412-664-203 Aft Crosstube, B29386	8803.20	1	\$ 1,000.00	\$ 1,000.00
2				\$ -	\$ -
3				\$ -	\$ -
4				\$ -	\$ -
5				\$ -	\$ -
6				\$ -	\$ -
7				\$ -	\$ -
8				\$ -	\$ -
9				\$ -	\$ -
10				\$ -	\$ -

All Prices are in US Dollars

All of the above parts were made in Canada and are returning to manufacturer in Canada

THIS IS A CUSTOMS INVOICE ONLY

Sub Total \$1,000.00

Total \$1,000.00

Amount Due: \$1,000.00

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada
Tel.: 1.613.632.5200
Fax: 1.613.632.1185
GST # RT101272607

S Bedford

From: Richard Fournier (DHL CA) [Richard.Fournier@dhl.com]
Sent: November 9, 2007 9:42 AM
To: S Bedford
Cc: Linda Preston (DHL CA)
Subject: RE: shipment from Mauritania

Hi Sue

As per our tel conversation this morning, Mauritania is covered by a DHL EXPRESS/COURRIER SERVICE office.

I went in their web-site to see what is the apprx cost for Door to Door (Montreal city limit area) for this shpmt and the price is Apprx: 1400.00 cad (this is a ball park price) of course this is excluding duty & taxes.

If you or yr shipper has already an account open with DHL Express, the above price may vary?.

Hope the above info will help you

Tks

Bst rgds

Richard Fournier
Customer service Manager
Chef de service à la clientèle
DHL Global Forwarding
555 Montée De Liesse
Ville St Laurent, QC, H4T 1P5

970810058

Direct: 514 734 4508
Tel : 514 344 3447 ext 4508
Mobile: 514 231 8044
Fax : 514 344 3648

-----Original Message-----

From: S Bedford [mailto:Sbedford@dartaero.com]
Sent: Friday, November 09, 2007 8:59 AM
To: Richard Fournier (DHL CA)
Subject: shipment from Mauritania

Richard, here is the information that you need.

Bristow Helicopters Mauritania
c/o Mauritania Helicopter Service
Aeroporte de Mauritania
Nouakchott, Mauritania
Paul Evans
0111737824745

The dims are 113 X 34 X 7 inches and the weight is 60lbs.
Customs value is \$1000.00USD

If you need any more information please let me know.

Sue Bedford
Dart Aerospace
613-632-5200



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Tel: 1.613.632.5200
Fax: 1.613.632.5246
E-mail: heli@dartaero.com

January 8, 2008

Chip (Ralph) Jeffries
Kuehne & Nagel International Ltd.
1145 Hunt Club Road
Suite 340
Ottawa, ON K1V 0y3
1-613-736-7424

Good morning Chip,

Please be advise that Dart Crosstube, D412-664-203A, B29386, returning to the manufacturer from Bristow Mauritania was manufactured at and was shipped from the Dart facility to Bell Helicopter Textron Mirabel on Feb 27, 2007. The Crosstube was subsequently installed on Bell 412 serial #36433. This aircraft departed from Canada, final destination Bristow Mauritania. We there for do not have any export documentation to accompany the return of this shipment to Canada. I have provided a copy of the waybill for shipment from the Dart facility in Hawkesbury, Ontario to Bell Helicopter Textron in Mirabel, QC. Also I have provided a copy of the packing slip.

The value of the goods returning is \$4647.17 usd.

Please proceed with customs clearance as Canadian goods returning to Canadian manufacturer.

Please don't hesitate to contact me should you require any additional information.

Best regards,

A handwritten signature in black ink, appearing to read "S. Willems".

Siân Willems
Marketing
DART Aerospace Ltd.